User: Job Number **Estimate Number** Prsht Rev. First Issue **Previous Run** Written By Checked & Approved By Comment

Monday, 07/04/2008 11:47:29 AM

Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

: 38436

: 10276

P.O. Number

: 07/04/2008 This Issue

: NC

: // : 36659

: Est Rev:C 04.02.26

S.O. No. :

: MACHINED PARTS Type

Part Number Drawing Number

Drawing Name

: D412698011

: IIN D412-698 REVD

: CABIN DOOR ROLLER KIT, LH

Project Number Drawing Revision

: N/A

Material

: 18/04/2008 **Due Date**

Qty:

Each

D3121-145 from Step 1.3 KJ/DS

Est Rev:D 08-01-28 change to rev D ECN 1104 DD

Additional Product

Job Number:



Sea. #:

Machine Or Operation:

Description:

1.0 DC DOCUMENT CONTROL

Change Qty of D3121-141 & remove



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

2.0

PACKAGING RESOURCE #1



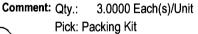
Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121141 Bracket Assembly



Total: 9.0000 Each(s)



Qty Part Number

Description



3 D3121-141

Bracket Assembly

D3121143

4.0

Comment: Qty.:

1.0000 Each(s)/Unit Total:

3.0000 Each(s)

Pick: Packing Kit

1 D3121-143

Qty Part Number Description

D3137043

Bracket Assembly

Bracket Assembly



Comment: Qty.:

Total:

3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

1.0000 Each(s)/Unit

Batch B29

Page 1 -

Monday, 07/04/2008 11:47:30 AM Date: User: ^ Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: CABIN DOOR ROLLER KIT, LH Part Number: D412698011 Job Number: 38436 Job Number: Seq. #: Description: **Machine Or Operation:** 1 D3137-043 Bracket Assembly _ D3183043 6.0 Bracket Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description Batch Bracket Assembly 3666 1 D3183-043 D31991 Bracket Comment: Qty.: 9.0000 Each(s)/Unit Total: 27.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description 9 D3199-1 **Bracket** D32021 8.0 Cover Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description 1 D3202-1 Cover INSPECT 100% KITS FOR COMPLETENESS QC4 9.0 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 10.0 **PACKAGING Comment: PACKAGING RESOURCE #1** Identify and pack for shipping as per PPP D412-698-011 Location: 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 08-04-09 Job Completion

6.0 PARTS LIST

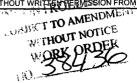
| Qty -011 | Qty -012 | Qty -013 | Qty -015 | Qty -017 | Qty -019 | Qty -021 | Part Number | Description |
|-------------------------|------------------|-------------|-------------|-------------|--------------|--------------|--------------|----------------------------|
| $\overline{\mathbf{x}}$ | | | | | | | D412-698-011 | CABIN DOOR ROLLER KIT, LH |
| | Х | | | | | | D412-698-012 | CABIN DOOR ROLLER KIT, RH |
| | | Х | | | | | D412-698-013 | DOOR HANDLE KIT |
| | | | X | | | | D412-698-015 | DOOR SUPPORT KIT |
| | | | | Х | | | D412-698-017 | REPLACEMENT DOOR TRACK KIT |
| | | | | | Х | | D412-698-019 | BEARING OVERHAUL KIT |
| | | | | | | Х | D412-698-021 | REPLACEMENT SHIM KIT |
| | | | | | 7 | | D3121-21 | BOLT |
| | | - | | | 5 | | D3121-21 | BEARING ASSEMBLY |
| 3 | 3 | | | | - | | D3121-241 | BRACKET ASSEMBLY |
| 1 | - | | | | | | D3121-141 | BRACKET ASSEMBLY |
| | 1 | | | | | | D3121-143 | BRACKET ASSEMBLY |
| | '- - | | | | 1 | | D3121-144 | GUIDE |
| | | | | | 1 | | D3137-5 | WASHER |
| 1 | 1 | | | | ' | | D3137-043 | BRACKET ASSEMBLY |
| | <u>'</u> | | | | 2 | | D3183-045 | BEARING ASSEMBLY |
| 1 | | | | | | | D3183-043 | BRACKET ASSEMBLY |
| | 1 | | | | | | D3183-044 | BRACKET ASSEMBLY |
| 9 | 9 | | | 9 | | | D3199-1 | BRACKET |
| 1 | 1 | | | 1 | | - | D3202-1 | COVER |
| | | | | | | | D3202-1 | |
| | | 4 | | _ | | _ | D3203-1 | HANDLE |
| | | 1 | | | | | D3220-041 | DOUBLER |
| | | 1 | | | | | D3220-042 | DOUBLER |
| | | 2 | | | | | D3220-3 | DOUBLER |
| | | | 2 | | | | D3200-1 | DOOR POST BLOCK |
| | | | 2 | | | | D3200-3 | DOOR WEDGE |
| | | | 2 | | | | D3201-1 | DOUBLER |
| - | | | 1 | | - | | D3201-3 | ANGLE |
| | | | 1 | | | | D3201-4 | ANGLE |
| - | | | | | | 3 | D3238-1 | SHIM |
| | | | | | | 1 | D3238-3 | SHIM |
| | | | | | - | 2 | D3238-5 | SHIM |
| | | | | | | 6 | D3238-11 | SHIM |
| | | | | - | | 2 | D3238-13 | SHIM |
| | | | | | | 4 | D3238-15 | SHIM |
| | | | | | | | | |
| | | | 12 | | | | AN960JD10L | WASHER |
| | | 8 | | | | | AN960JD416L | WASHER |
| | | | 12 | | | | MS21042L3 | NUT (OR MS21042-3) |
| | | 8 | | | | | MS21042L4 | NUT (OR MS21042-4) |
| | | 16 | | | | | MS24694-S98 | SCREW |
| | | | | | 1 | | MS24694-S101 | SCREW |
| | | | 12 | | | | MS24693-S277 | SCREW |

(CONTINUED ON PAGE 15)

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Date: 07.07.03

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| (CONTINUED | EROM. | DAGE 14) |
|------------|-------|----------|
| | | |

| Qty -023 | Part Number | Description |
|-------------|--------------|----------------------------|
| Х | D412-698-023 | AUTOMATIC DOOR OPENER KIT |
| 1 | D3552-11 | GAS SPRING |
| 1 | D3594-041 | DOOR DOUBLER ASSEMBLY |
| 1 | D3594-043 | FLOOR DOUBLER ASSEMBLY, LH |
| 1 | D3594-044 | FLOOR DOUBLER ASSMEBLY, RH |
| 2 | D3622-1 | BALL STUD |
| 2 | AN960JD516L | WASHER |

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